

Work Order ID 60063

June 24, 2010 8:57:01 AM



Page 1

Item ID: D3201-4

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 6/24/10

Start Qty: 10.00



Cust Item ID:

Required Date: 6/29/10

Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3201

Rev B

100

0.00



FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3201

1 Dwg Rev: B

1 Prog Rev: B

12-

Deburr if necessary

2024 . 050

1810-6-29

(14)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

1810-6-29

120

0.00



QC8- Inspect parts - second check

0.00

QC

Memo

Quality Control

S 10/06/29

(14)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60063

June 24, 2010 8:57:02 AM



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Start Date: 6/24/10

Start Qty: 10.00



Cust Item ID:

Required Date: 6/29/10

Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

Deburr Stack

N/A

140



Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

1-Bend as per Dwg D3201
dwg D3201

12-Scribe part# and Batch# per

SD 10/06/30

14

150



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

SD 10/06/30

14

-4

W/O:		WORK ORDER CHANGES						
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Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 6/24/10

Start Qty: 10.00



Cust Item ID:

Required Date: 6/29/10

Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

14 10-6-30

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

=) 14 10/07/01

14 4

180



Packaging

Packaging

Identify as per dwg & Stock Location: 041

0.00

Memo

0.00

14 10/07/01

14

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 60063

June 24, 2010 8:57:03 AM



Item ID: D3201-4

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 6/24/10 Start Qty: 10.00



Cust Item ID:

Required Date: 6/29/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/01 *[Signature]*

UMF
10-7-01

W/O:		WORK ORDER CHANGES						
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Picklist Print

June 24, 2010 8:57:01 AM

Page 1

Work Order ID: 60063

Parent Item: D3201-4

Parent Item Name: Doubler



Start Date: 6/24/10

Required Date: 6/29/10

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev: A Removed from 9 Digit 06-01-25 JLM
 IPP Rev: B Now on Waterjet 06-08-14 JLM
 IPP Rev: C Added scribing, NCR262 07.11.29 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.050

Purchased

No

100

sf

118.6947

0.045

0.473684



2024-T3 .050 sheet



168
1810-6-09

Location

Loc Qty

Loc Code

MAT22

118.6947

111381

22.3

113189

0.3947

114968

96

111381

(14)

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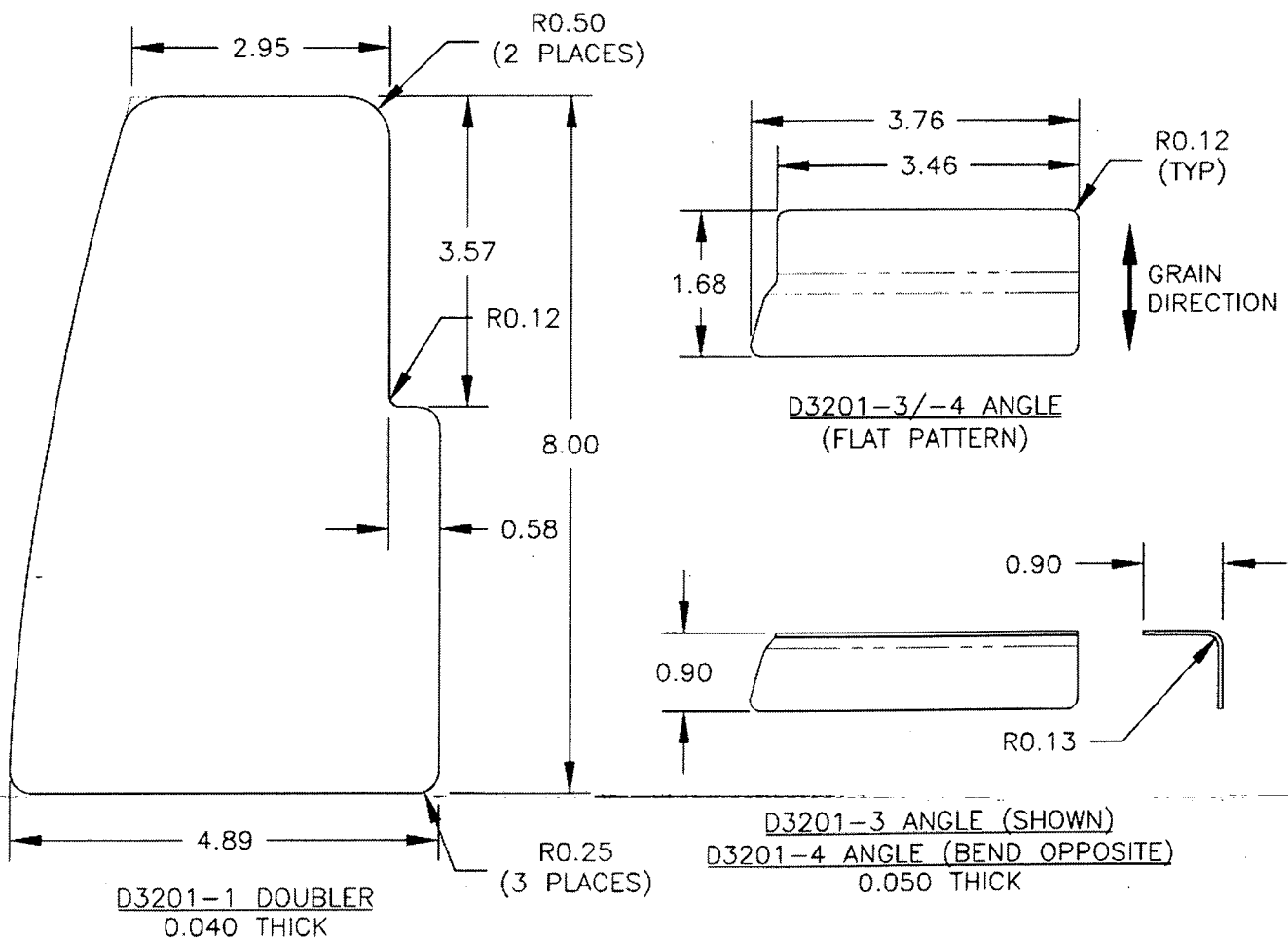
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3201	REV. B SHEET 1 OF 1
DATE 03.11.03		TITLE DOUBLER	SCALE 1:2
A	03.08.07	NEW ISSUE	
B	03.11.03	MODIFY D3201-1, ADD D3201-3/-4	



D3201-1/-3/-4 DOUBLER

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)
(REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

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